

Work Order ID 131346-2

131346

ASAP

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Item ID: D3859-041 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearplate
 Start Date: 4/02/15 Start Qty: 12.00 *12* Cust Item ID:
 Required Date: 4/10/15 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: MLS Date: 150402 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3859	B								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3859-1 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

APR 03 2015

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Item ID: D3859-041 Accept ***N9000040100*** Setup Start ***NS1***
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 Item Name: Wearplate
 Start Date: 4/02/15 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 4/10/15 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Large Fab	0.00							
130									
Large Fab	Memo	0.00							
Large Fab	1-Weld D4379-5 cups as per dwg D3859 A/R 316L stainless steel rod Batch: <u>M123823</u>								
	2-Weld hard facing as per Dwg D3859 A/R 2059B Hard Coat rod Batch: <u>M129694</u>								
	*****use DT9462 for welding*****								
140	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
140									
QC	Memo	0.00							
Quality Control									

8 015-5-21

8x **DAS 43 9-89** **MAY 21 2015**

105 15 YAM

PAC
ST
240

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Item ID: D3859-041 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearplate
 Start Date: 4/02/15 Start Qty: 12.00 *12* Cust Item ID:
 Required Date: 4/10/15 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				8x		DAS 43 9-89	MAY 21 2015
160 *160* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 12/30 F/K. Memo START TIME: 3:30 OVEN TEMPERATURE: 320° FINISH TIME: 4:00	0.00 0.00				8 φ	15-5-20	DAS 34 9-89	
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				⑧		DAS 38 9-89	MAY 22 2015

11

12

13

14

30
100

100
100

✓

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Item ID: D3859-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearplate
 Start Date: 4/02/15 Start Qty: 12.00 *12* Cust Item ID:
 Required Date: 4/10/15 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: <u>54613</u>	0.00				<u>8</u>	<u>116</u>		MAY 22 2015
180									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00				<u>MLJ</u>			MAY 25 2015
Quality Control									

MF
15-5-22

Picklist Print

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Work Order ID: 131346

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Parent Item: D3859-041

D3859-041

Parent Item Name: Wearplate

Start Date: 4/02/15

Required Date: 4/10/15

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 09-02-03 new issue DD verified by:EC
14.04.30 as per dwg rev.b DD verified by:JLM

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4379-5		Manufactured	No			130	Each	132.0000	6	72			

D4379-5

Wearplate Cup

Q 15-5-19

Location

Loc Qty

Loc Code

ST103

4

126889

4

WA001

128

129499

100

129613

28

48

M304S16GA

Purchased

No

100

sf

454.8176

0.85

11

M304S16GA

304/316 Sheet .063

Q 15/04/05

Location

Loc Qty

Loc Code

MAT019

454.8176

m131384

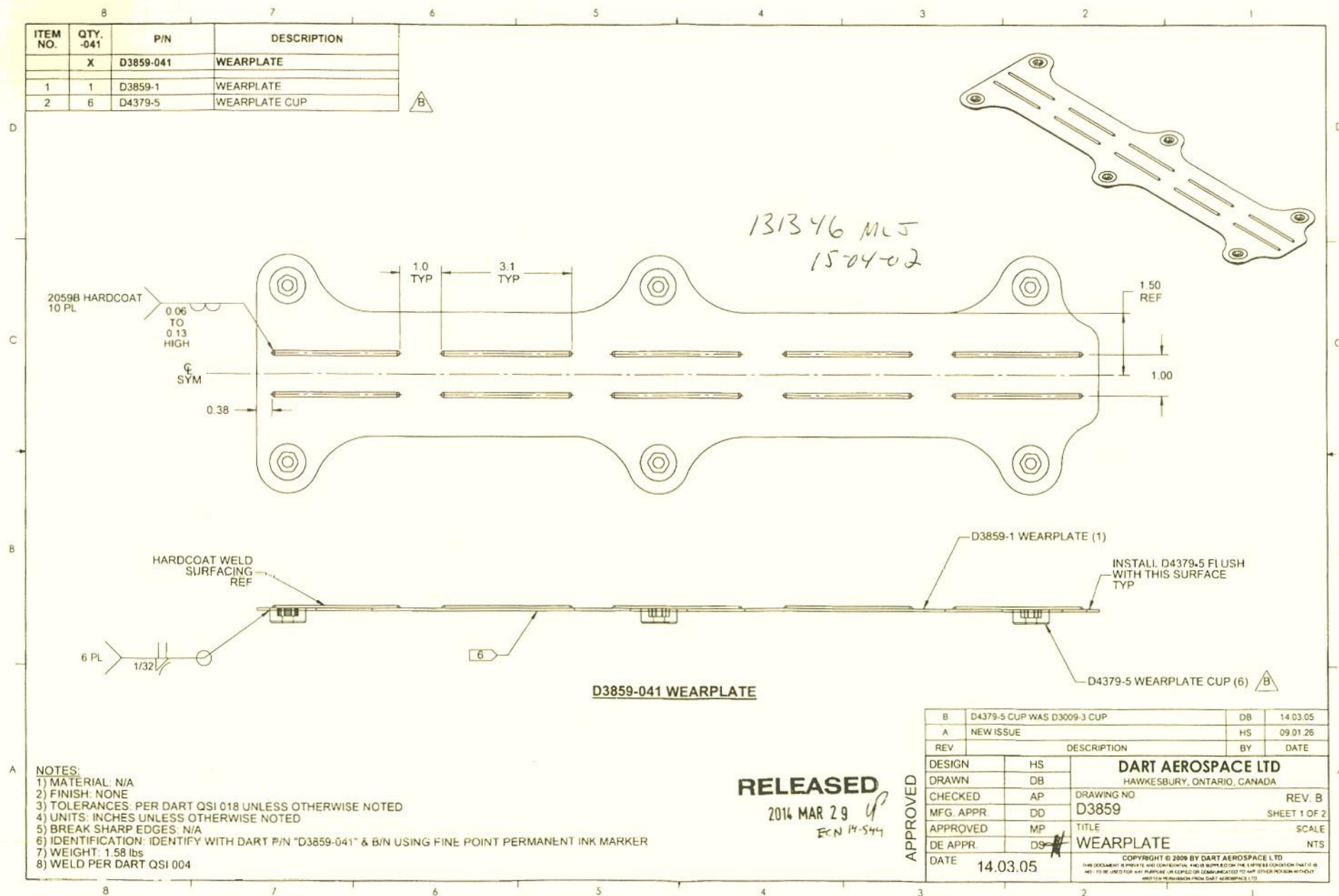
195.8176

m131503

259

138

ITEM NO.	QTY. -041	P/N	DESCRIPTION
	X	D3859-041	WEARPLATE
1	1	D3859-1	WEARPLATE
2	6	D4379-5	WEARPLATE CUP



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3859-041" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.58 lbs
- 8) WELD PER DART QSI 004

RELEASED

2014 MAR 29

ECN 14-544

APPROVED

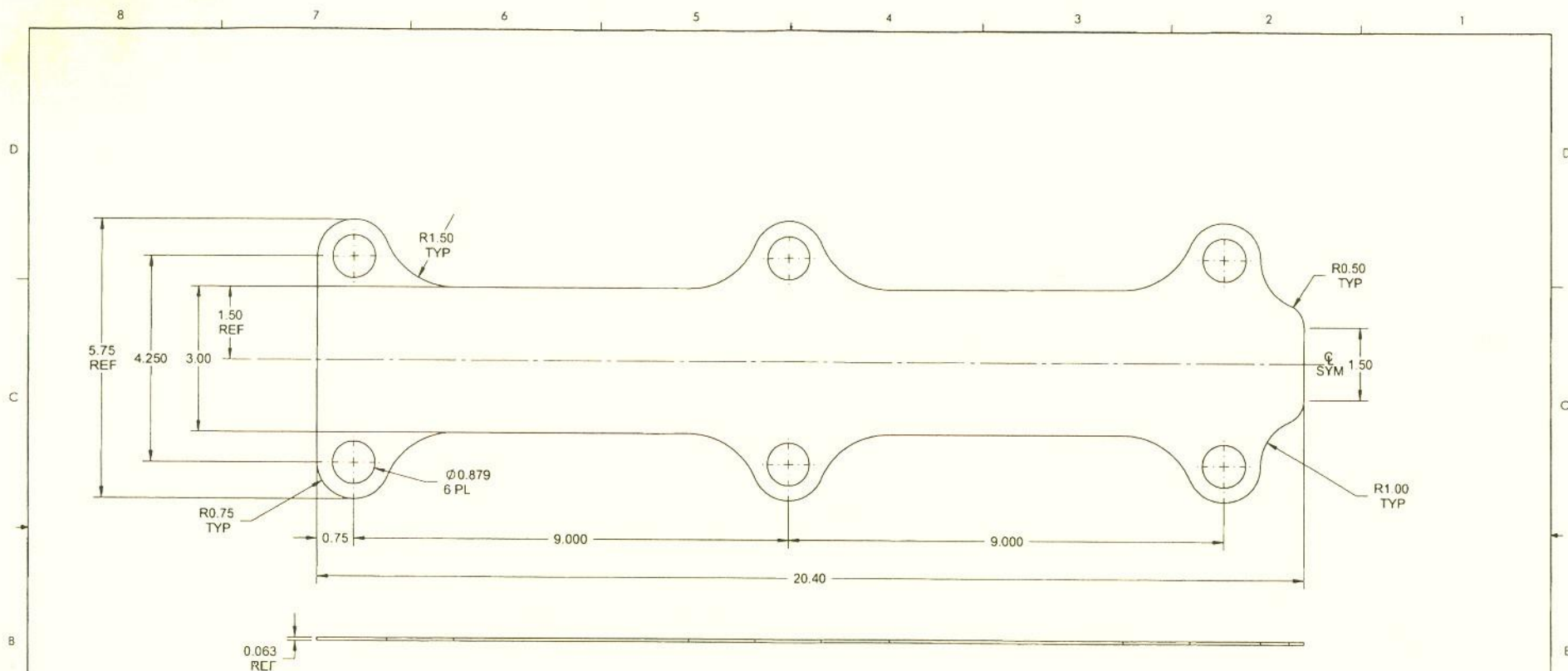
B	D4379-5 CUP WAS D3009-3 CUP	DB	14.03.05
A	NEW ISSUE	HS	09.01.26
REV	DESCRIPTION		BY DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP		
MFG. APPR	DD		
APPROVED	MP		
DE APPR	DS	TITLE	
DATE		WEARPLATE	
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REV. B

SHEET 1 OF 2

SCALE

NTS



D3859-1 WEARPLATE

RELEASED

2014 MAR 29 *up*

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK),
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524 (REF DART SPEC M304S16GA)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.29 lbs

APPROVED	DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	DB		
	CHECKED	AP	DRAWING NO.	REV. B
	MFG. APPR.	DD	D3859	SHEET 2 OF 2
	APPROVED	MP	TITLE	SCALE
	DE APPR.	DS	WEARPLATE	NTS
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